

Work Order ID 64825

Friday, December 17, 2010 8:04:34 AM



Page 1

Item ID: D3208-3

Accept



Setup Start



Revision ID:

Item Name: Pedal Mount Angle

Stop



Start Date: 12/16/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 1/19/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

ML

Date: 10/12/17

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3208

Rev A1

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3208

☐ Dwg Rev: A1

☐ Prog Rev: A1

☐ 2-

Debur if necessary

B11-1-3

⑥

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B11-1-3

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

S 12/17/10

⑥

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Revision ID:

Stop



Item Name: Pedal Mount Angle

Start Date: 12/16/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 1/19/2011 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Brake NC

NC BRAKE

0.00

Memo

0.00

Debur D3208-3 Form D3208-3 as per Dwg D3208 Polish any marks on part within 01. of Dwg D3208

SA 11/10/10

5

X

PTD

140



QC

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Quality Control

Sulalos

X

150



HandFinish

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

Hand Finishing

5 BR 11-01-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3208-3 PAR #: _____ Fault Category: Small Fab. NCR: Yes No DQA: ✓ Date: 14/01/05
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: ✓ Date: 11/01/06

NCR: <u>64825</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>11/01/05</u>	<u>130</u>	<u>1 part was out of Tolerance. Slipped while bending & Bend was on An Angle across the part. Re process</u>	<u>[Signature]</u> <u>12/01/02</u>	<u>Scrap & destroy</u> <u>Qty 1 no replace</u>	<u>[Signature]</u> <u>14/01/05</u>	<u>8</u> <u>11/01/05</u>	<u>[Signature]</u> <u>12/01/02</u>	<u>[Signature]</u> <u>14/01/05</u>

NOTE: Date & initial all entries

Work Order ID 64825

Friday, December 17, 2010 8:04:34 AM



Page 3

Item ID: D3208-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Pedal Mount Angle

Start Date: 12/16/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 1/19/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

=> Jd

11/01/05

58

170

Identify as per dwg & Stock Location: 202

0.00



Packaging

Memo

0.00

Packaging

Cll/01/06 5

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

CK 11/01/06

NLF
11-01-06

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NOTE: Date & initial all entries

Picklist Print

Friday, December 17, 2010 8:04:38 AM

Page 1

Work Order ID: 64825

Parent Item: D3208-3

Parent Item Name: Pedal Mount Angle





Start Date: 12/16/2010

Required Date: 1/19/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: B 04.05.25 Material changed for Step 4 KJ/JLM
IPP Rev:C Now on Waterjet 06-10-12 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063 		Purchased	No			100	sf	148.6340	0.0659	0.277474	5		
6061-T6 .063 Sheet											1B11-1-3		

Location	Loc Qty	Loc Code
MAT	111	
116308	111	
MAT21	37.634	
113608	37.634	

116308

(6)

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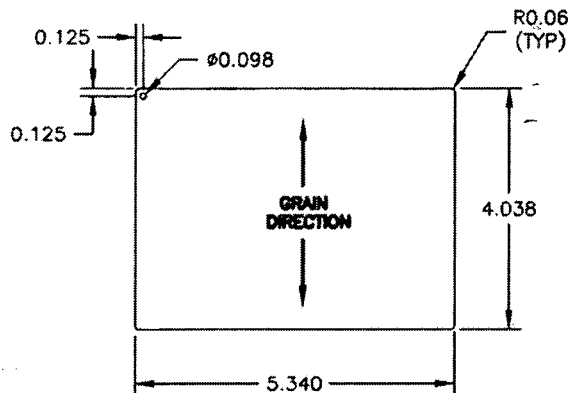
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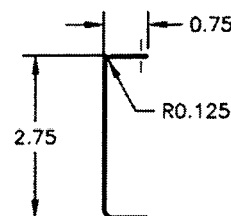


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DATE 04.01.27		TITLE DOUBLER	SCALE 1:3
A	04.01.27	NEW ISSUE	
AI	H 04.05.25	CHANGE DIM, NOTE 3) CHANGE	

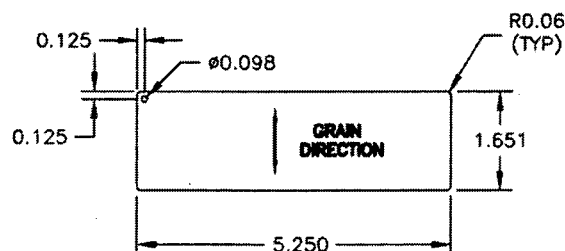
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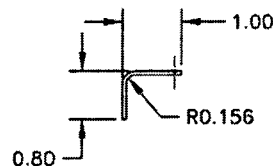
2 D3208-1 DOUBLER
FLAT PATTERN



D3208-1 DOUBLER
BEND DETAIL



3 D3208-3 PEDAL MOUNT ANGLE
FLAT PATTERN



D3208-3 PEDAL MOUNT ANGLE
BEND DETAIL

SHOP COPY
RETURNED TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 64825

04/10/2017

NOTES:

- 1) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040" THICK (M2024T3S.040)
- 3) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063" THICK (M2024T3S.063)
- 4) MATERIAL: 2024-T3 (QQ-A-250/4) 0.080" THICK (M2024T3S.080)
- 5) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES



- 3) MATERIAL: 6061-T6 (QQ-A-250/11) 0.063" THICK (M6061T6S.063)

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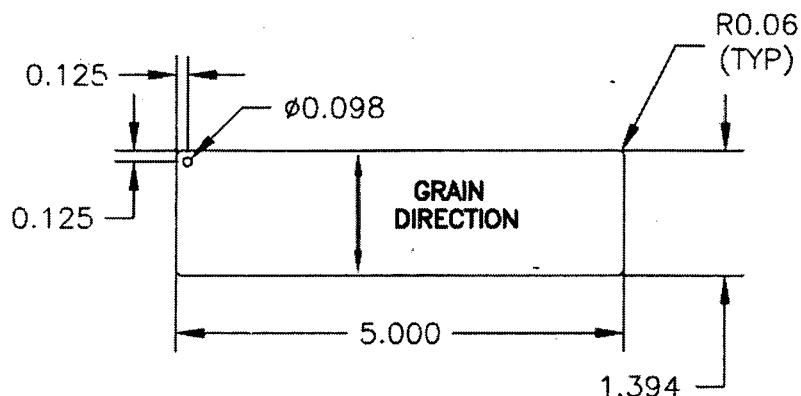
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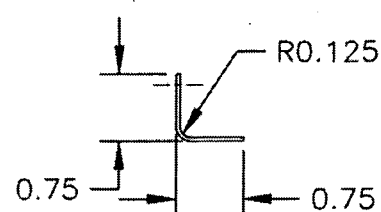
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CHECKED RT	APPROVED RT	DRAWING NO. D3208	REV. A SHEET 2 OF 3
DATE 04.01.27		TITLE DOUBLER	SCALE 1:2

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04.04.05

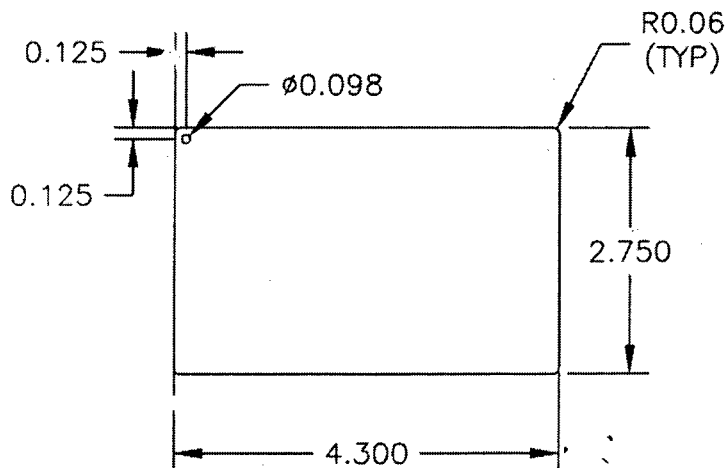
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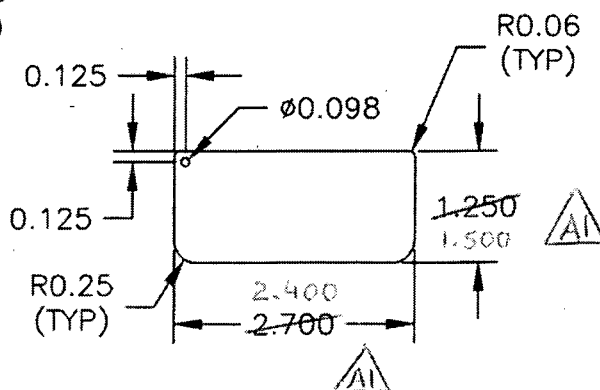
2 D3208-5 MOUNT ANGLE
FLAT PATTERN



D3208-5 MOUNT ANGLE
BEND DETAIL



2 D3208-7 FILLER



2 D3208-11 FILLER

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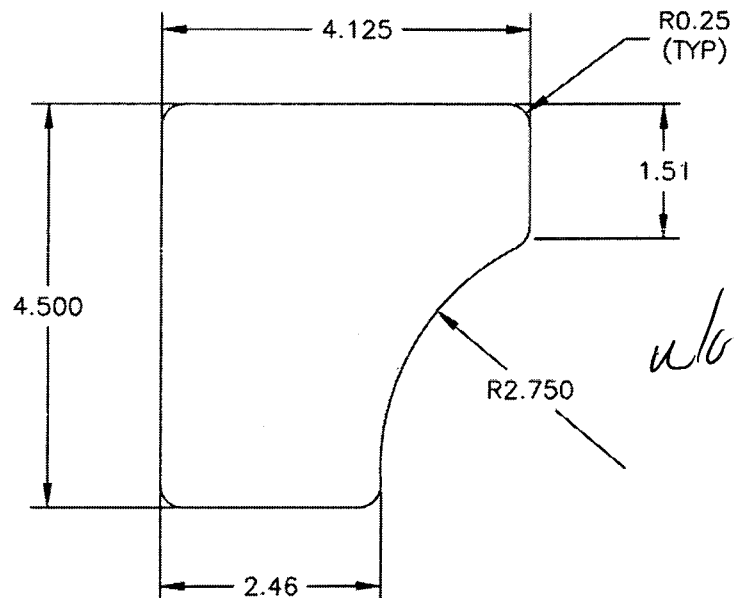
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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3208	REV. A SHEET 3 OF 3
DATE 04.01.27		TITLE DOUBLER	SCALE 1:2

RELEASED
04.04.05 [Signature]



D3208-9 DOUBLER

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